

Work Order ID 118357

June-20-14 10:06:23 AM

118357

Page 1

Item ID: D206-642-611

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH, High Gear, Standard Wearplates (2.5" Bolt Spacing on Aft Saddle), DART (Apical) Tri-Bag

Start Date: 6/20/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/20/14 Req'd Qty: 1.00 ***1***

Customer:

Reference: add D206-642-649 for trial fit @ Oceanside - Sian

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D206-642	Q								

100 Document Control 0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-611 CHS006

N/A original paperwork in box

105 0.00

105

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STK:
1 X D206-642-611 B113823
ASSEMBLE CUSTOM KIT TO SKID:
1 X D206-642-649 B 112621

1x of del 14/06/20

110 Pick Kit

110

Packaging

Memo

0.00

Packaging

ENSURE ORIGINAL KIT IS IN BOX

JUN 24 2014

DAS
06
9-89

test fit

QC5

Shp
14/06/20

Work Order ID 118357

118357

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Item ID:	D206-642-611	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Skidtube LH, High Gear, Standard Wearplates (2.5" Bolt Spacing on Aft Saddle), DART (Apical) Tri-Bag					
Start Date:	6/20/14	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	6/20/14	Req'd Qty:	1.00	*1*	Customer:	
Reference:	add D206-642-649 for trial fit @ Oceanside - Sian					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						NR1
						NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	RPACKAGE PER PPP USING NEW B/N Identify and pack for shipping as per PPP D206-642-611 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUN 24 2014
DAS
06
9-89

JUN 20 2014

DAS
06
9-89

MIS 14-06-27

W40627

Picklist Print

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Page 1

Work Order ID: 118357

118357

Parent Item: D206-642-611

D206-642-611

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates (2.5" Bolt Spacing on Aft Saddle), DART (Apical) Tri-Bag

Start Date: 6/20/14

Required Date: 6/20/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.27Revised pick listKJ/EC
IPP Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:ec
IPP Rev:D 09-01-06 update part list DD verified by:EC IPP REV:E
13.09.05 CHG005/ ECN13-634 DD VERF:JLM IPP REV:F 14.04.28
AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-642-611 Manufactured No

Each 2.0000

1

D206-642-611

113823

Skidtube LH, High Gear, Standard Wearplates (2.5" Bolt Spacing on Aft Saddle), DART (Apical) Tri-Bag

Location

Loc Qty

Loc Code

FG

2

78678

1

81282

1

D206-642-649

Manufactured No

Each 0.0000

1

D206-642-649

Run-On Landing Wearplate

170651

u

- 18.3 Install the D3805-041/-043/-045/-047 Wearplate Assembly using the qty(7) AN3-36A bolts and associated hardware. Torque AN3-36A fasteners to 15-25 in-lb (1.7-2.8 N-m).
- 18.4 Re-install the Skidtubes on the aircraft per Section 32.2 of ICA-D206-642.
- 18.5 Update weight and balance information per Section 5.0 of this document. Customers upgrading D206-642-111/-112 Skidtubes should adopt Weight & Balance of D206-642-113/-114 Skidtubes and customers upgrading D206-642-211/-212/-213/-214 Skidtubes should adopt Weight & Balance of D206-642-215/-216/-217/-218 Skidtubes.
19. Installation of the D206-642-349 Run-on Landing Wearplate Kit on the D206-642-311/-312 Skidtubes and D206-642-449 Run-on Landing Wearplate Kit on the D206-642-411/-412 Skidtubes:
- 19.1 Remove the D206-642-311/-312/-411/-412 Skidtubes per Section 32.1 of ICA-D206-642. Remove existing wearplates/wearshoes/wearpads/gaskets. Inspect the bottom of the tube for damage and touch up finish per Section 5.2.11 of ICA-D206-642. Plug existing wearplate inserts using Sikaflex-241/-291 or Proseal 890.
- 19.2 On both sides of the skidtube, transfer drill qty(4) $\varnothing 0.375$ " holes from the D4364-041/-043 Wearplate Assembly to the D206-642-311/-312 Skidtubes and transfer drill qty(3) $\varnothing 0.375$ " holes from the D4366-041/-043 Wearplate Assembly to the D206-642-411/-412 Skidtubes. Countersink the holes on both sides to $\varnothing 0.450$ " X 45° and deburr. Touch up finish per Item 5.2.11 of ICA-D206-642. Install D2649 Spacers with Magnobond 6398. Grind flush as required. Allow magnobond to cure per manufacturer's instructions. Counterbore the spacers $\varnothing 0.313$ " x 0.75" on each side.
- 19.3 Install the D4364-041/-043, D4366-041/-043 Wearplate Assembly using the qty(9) AN3-36A bolts and associated hardware. Torque AN3-36A fasteners to 15-25 in-lb (1.7-2.8 N-m).
- 19.4 Re-install the Skidtubes on the aircraft per Section 32.2 of ICA-D206-642.
- 19.5 Update weight and balance information per Section 5.0 of this document. Customers upgrading D206-642-311/-312 Skidtubes should adopt Weight & Balance of D206-642-313/-314 Skidtubes and customers upgrading D206-642-411/-412 Skidtubes should adopt Weight & Balance of D206-642-413/-414 Skidtubes.
20. Installation of the D206-642-549 Run-on Landing Wearplate Kit on the D206-642-511/-512/-513/-514 Skidtubes:
- 20.1 Remove the D206-642-511/-512/-513/-514 Skidtubes per Section 32.1 of ICA-D206-642. Remove existing wearplates/wearshoes/wearpads/gaskets. Inspect the bottom of the tube for damage and touch up finish per Section 5.2.11 of ICA-D206-642. Plug existing wearplate inserts using Sikaflex-241/-291 or Proseal 890.
- 20.2 On both sides of the skidtube, transfer drill qty(2) $\varnothing 0.313$ " holes from the D4368-041/-043 Wearplate Assembly to the D206-642-511/-512/-513/-514 Skidtubes. Chamfer the holes on both sides to 0.030" X 45° and deburr. Touch up finish per Item 5.2.11 of ICA-D206-642. Install D3275-1 Spacers with Magnobond 6398. Grind flush as required. Allow magnobond to cure per manufacturer's instructions.
- 20.3 Install the D4368-041/-043 Wearplate Assembly using the qty(10) AN3-XXA bolts and associated hardware. Torque AN3-XXA fasteners to 15-25 in-lb (1.7-2.8 N-m).
- 20.4 Re-install the Skidtubes on the aircraft per Section 32.2 of ICA-D206-642.
- 20.5 Update weight and balance information per Section 5.0 of this document. Customers upgrading D206-642-511/-512 Skidtubes should adopt Weight & Balance of D206-642-515/-516 Skidtubes and customers upgrading D206-642-513/-514 Skidtubes should adopt Weight & Balance of D206-642-517/-518 Skidtubes.
21. Installation of the D206-642-649 Run-on Landing Wearplate Kit on the D206-642-611/-612/-613/-614 Skidtubes:
- 21.1 Remove the D206-642-611/-612/-613/-614 Skidtubes per Section 32.1 of ICA-D206-642. Remove existing wearplates/wearshoes/wearpads/gaskets. Inspect the bottom of the tube for

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Revision: Q

Date: 13.08.12

- damage and touch up finish per Section 5.2.11 of ICA-D206-642. Plug existing wearplate inserts using Sikaflex-241/-291 or Proseal 890.
- 21.2 On both sides of the skidtube, transfer drill qty(6) Ø0.313" holes from the D4370-041/-043 Wearplate Assembly to the D206-642-611/-612/-613/-614 Skidtubes. Chamfer the holes on both sides to 0.030" X 45° and deburr. Touch up finish per Item 5.2.11 of ICA-D206-642. Install D3275-1 Spacers with Magnobond 6398. Grind flush as required. Allow magnobond to cure per manufacturer's instructions.
 - 21.3 Install the D4370-041/-043 Wearplate Assembly using the qty(8) AN3-XXA bolts and associated hardware. Torque AN3-XXA fasteners to 15-25 in-lb (1.7-2.8 N-m).
 - 21.4 Re-install the Skidtubes on the aircraft per Section 32.2 of ICA-D206-642.
 - 21.5 Update weight and balance information per Section 5.0 of this document.

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Revision: **Q**

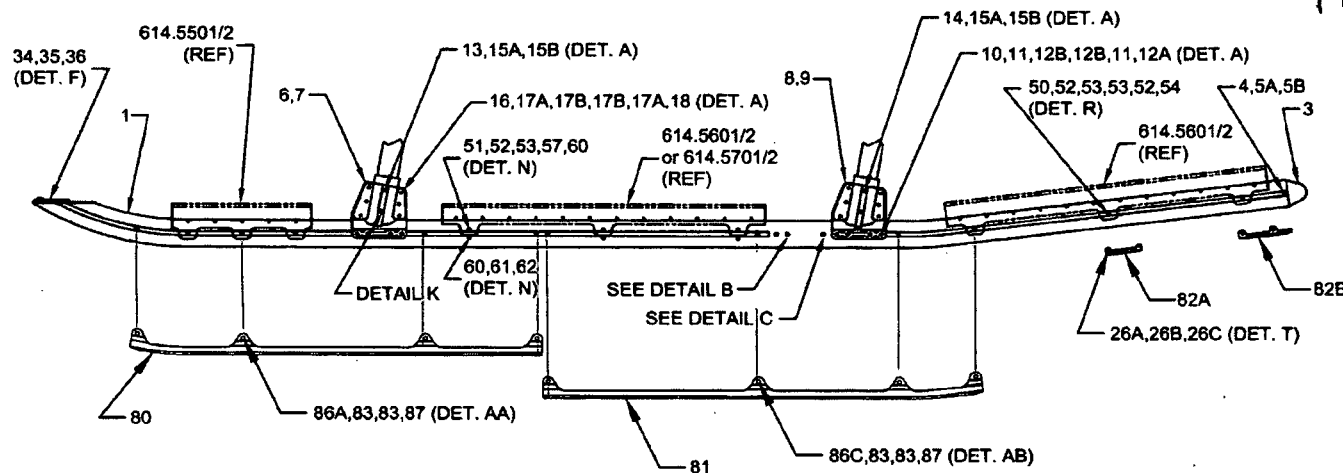
Date: 13.08.12

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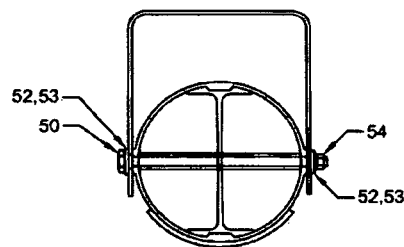
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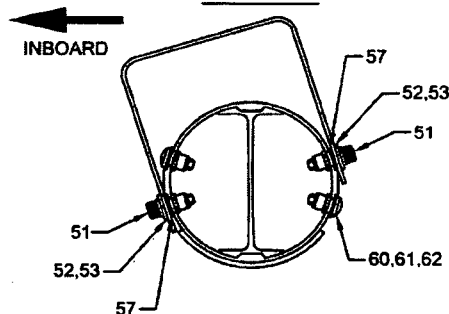
JIN-D206-642
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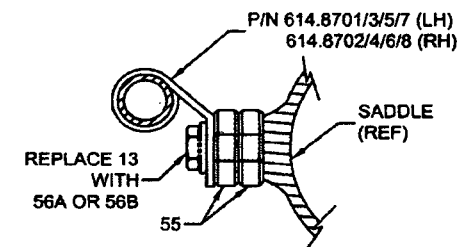
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4 PL



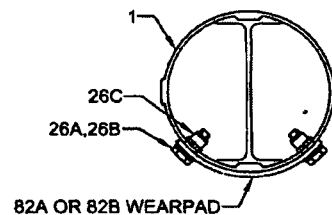
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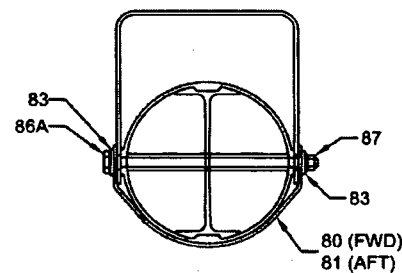
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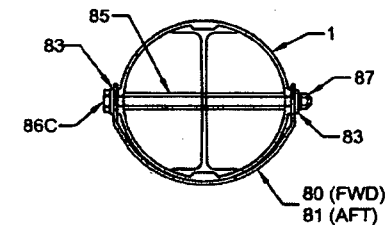
DETAIL T



DETAIL AA
2 PL



DETAIL AB
6 PL



206 A/B FLOAT SKIDTUBES w/RUN-ON LANDING WEARPLATES (TRI-BAG FLOATS)
(D206-642-611/-612/-613/-614)

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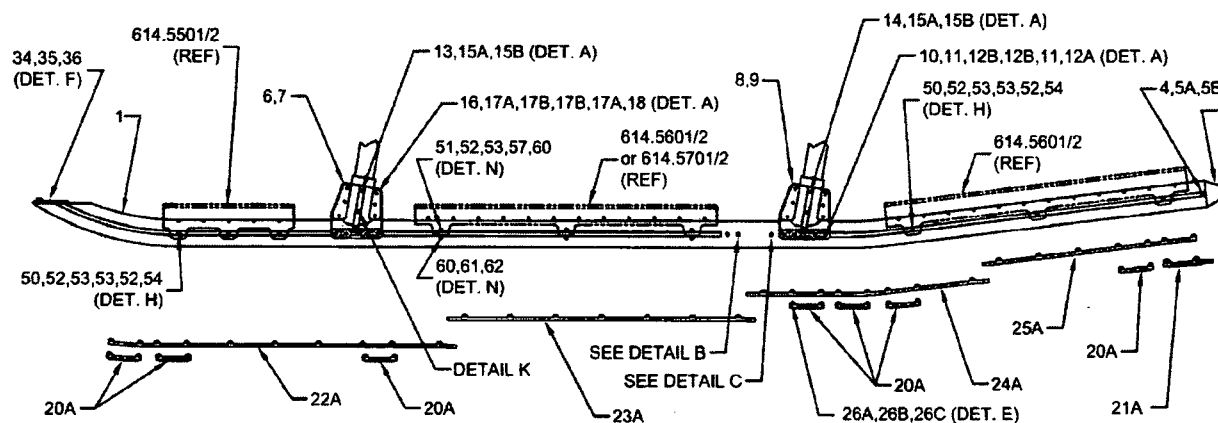
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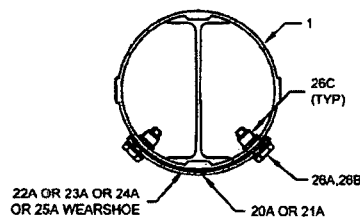
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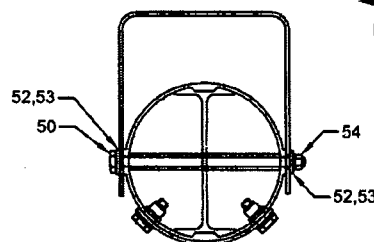
Q 14/6/23



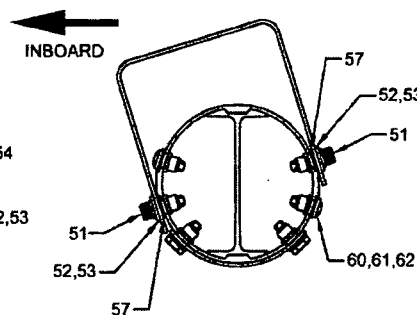
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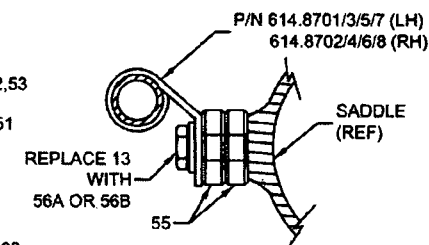
DETAIL H



DETAIL N



DETAIL K



206 A/B FLOAT SKIDTUBES (TRI-BAG FLOATS)
(D206-642-611/-612/-613/-614)

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Revision: Q

Date: 13.08.12

Picklist Print

February-03-14 7:42:16 AM

Page 3

Work Order ID: 112621

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

250

Each

296.0000

2

2

Cherry Rivet

Location

Loc Qty

Loc Code

ST327

296

m126282

132

m126333

164

CR3212-4-03

Purchased

No

250

Each

1,183.0000

2

2

Cherry Rivet

Location

Loc Qty

Loc Code

ST327

1083

114889

1

119017

700

m123265

382

st552

100

m114859

100

ALS7-1032-130

Purchased

No

250

Each

856.0000

64

64

Rivnut

Location

Loc Qty

Loc Code

FG

100

121444

100

ST279

756

119530

73

122763

22

124226

50

m126109

611

D3535-15

Stainless Steel Wearplate Fwd

Manufactured

No

270

Each

15.0000

1

1

Location

Loc Qty

Loc Code

FP002

15

106776

2

110201

13

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Work Order ID: 112621

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

D3535-21 Manufactured No 270 Each 5.0000
Stainless Steel Wearplate Center Fwd

1 ll 1 1/10/3/12

Location	Loc Qty	Loc Code
FP001	5	B110678
102342	5	

x1

D3535-35 Manufactured No 270 Each 5.0000
Stainless Steel Wearplate Aft

1 ll 1 1/10/3/12

Location	Loc Qty	Loc Code
FG	2	B112440
94685	2	
FP002	3	
108053	3	

x1

D3535-41 Manufactured No 270 Each 7.0000
Stainless Steel Wearplate Center Aft

1 ll 1 1/10/3/12

Location	Loc Qty	Loc Code
FP002	7	
42256	7	

x1

D3536-15 Manufactured No 270 Each 17.0000
Gasket Fwd

1 ll 1 1/10/3/12

Location	Loc Qty	Loc Code
FG	4	B113051
85604	2	
93893	2	
FP001	13	
107965	1	
110698	12	

x1

D3536-21 Manufactured No 270 Each 7.0000
Gasket Center

1 ll 1 1/10/3/12

Location	Loc Qty	Loc Code
FP001	7	
104203	7	

x1

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Shop Packet Print

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Picklist Print

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Work Order ID: 112621

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube Apical Tri-Bag Float Compatible (Fits LH or RH)

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

D3536-35

Gasket Aft

Manufactured No

270 Each 14.0000

1

Location

Loc Qty

Loc Code

FG

6

B112374

89650

2

93911

4

FP001

8

109783

8

D3536-41

Gasket Center Aft

Manufactured No

270 Each 9.0000

1

Location

Loc Qty

Loc Code

FP001

9

51646

9

D3537-1

Wearpad

Manufactured No

270 Each 18.0000

7

Location

Loc Qty

Loc Code

FG

18

B113282

79833

8

88562

10

D3537-3

Wearpad

Manufactured No

270 Each 21.0000

1

Location

Loc Qty

Loc Code

FG

8

B111825

86237

8

FP002

13

103014

13

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